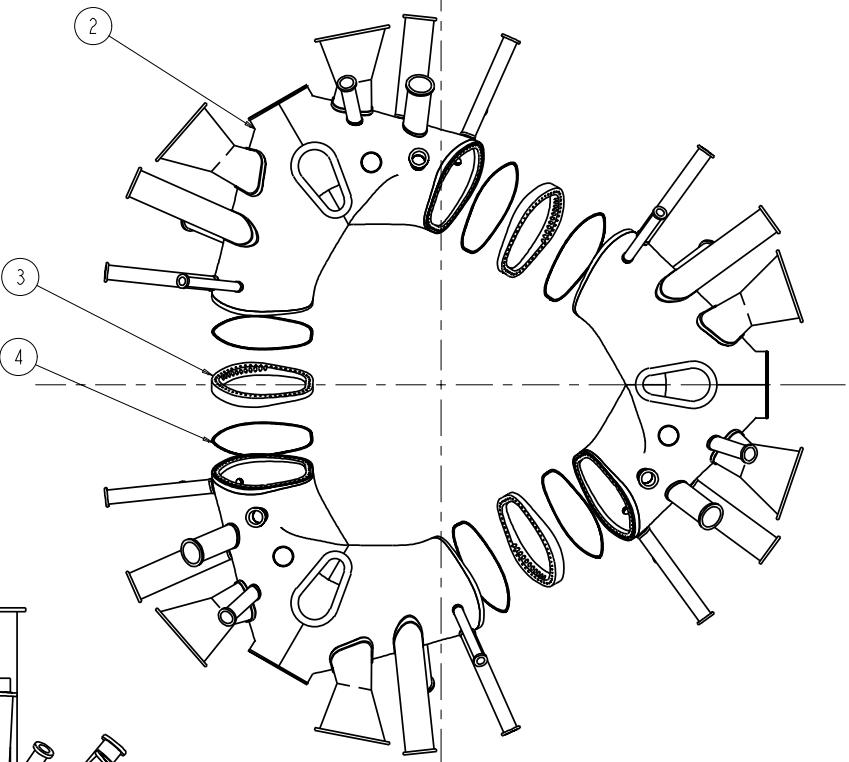
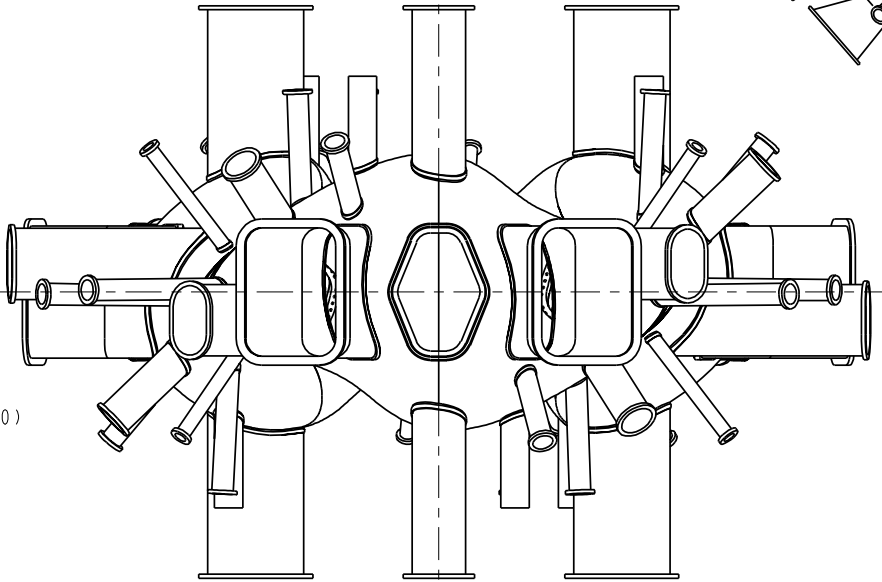
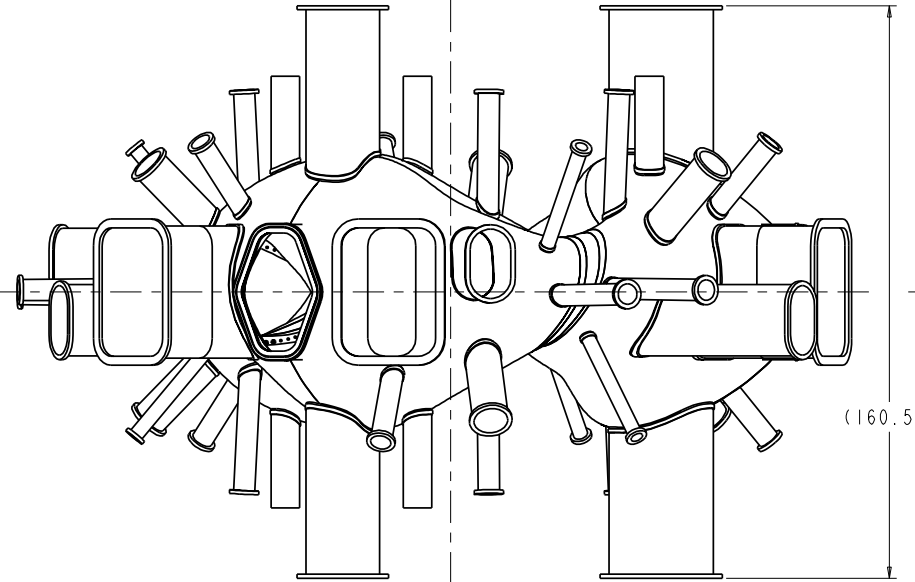


TYPICAL FLANGE/SEAL CONFIGURATIONS

- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSION ARE IN INCHES.
 3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL ARE DEFINED IN THE DRAWINGS, MODELS, AND SPECIFICATION.
 4. THE VACUUM VESSEL GEOMETRY IS DEFINED IN CAD MODELS/FILES SE120-001.ASM, SE120-002.ASM, AND SE121-019.PRT.
 5. ADDITIONAL TOLERANCE LIMITS ARE DEFINED IN DOCUMENT NCSX-12-122002-PH
 6. HELIUM LEAK TEST SHALL SHOW NO DETECTABLE LEAK WITH THE DETECTOR SENSITIVITY SET AT 1.0×10^{-9} STD-CC/SEC.



EXPLODED VIEW
SCALE 0.040



① SCALE = 0.060
Weight = 18808 lbs

PRELIMINARY
FOR INFORMATION ONLY

QTY	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
54	.625-11UNC-2B	NUT, DOUBLE HEXAGON			7
54	.625-11UNC-2A X 1.38 LG	STUD, ALLEN WRENCH			6
192	.625-11UNC-2A X 1.38 LG	BOLT, TENSION			5
6	-4	VACUUM VESSEL SEAL			4
3	SE121-019	VACUUM VESSEL SPACER			3
3	SE120-002	VACUUM VESSEL PERIOD ASSEMBLY			2
X	SE120-001	VACUUM VESSEL ASSEMBLY			1

← NEXT ASSEMBLY

QUALITY VERIFICATION
MECHANICAL AND STRUCTURAL
REFERENCE ORNL DA-665

OR CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO.
303	MATERIAL TEST REPORT	X
323	MATERIAL SEALER CERT	X
324	SPECIAL MATERIAL INSPECTION REPORT	X
285	TEMPERATURE INSPECTION AND TEST PLAN	X
313	WELD INSPECTION AND TEST PLAN	X
321	WELD AND WELD INSPECTION REPORT	X
322	WELD TEST REPORT (REQUIRED)	X
310	LEAK TEST REPORT	X
315	CLEARING CERT	X
318	DEVIATION REQUEST	X
319	NONCONFORMANCE REPORT	X
323	TOUCHES LOCAL REPORT	X
330	FUNCTIONAL TEST REPORT	X

100 LOCKED/KEYLOCK X
 * SYMBOL X INDICATES APPLICABLE TO ALL PARTS ON ITEM

NO REPRESENTATION OR WARRANTY EXPRESSED OR IMPLIED IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO OTHERS ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE DRAWING CONTRACTOR.

P THIS DRAWING PRODUCED ON PRO-ENGINEER

REV	DESCRIPTION	DATE	BY	CHK	SECT	DEPT	DATE	REV	DATE	CHK	DATE	DOE	DATE	DA	CV	EC	EE	EM	JE	N	PD	SE	ST	XAD	PES
A	GEN REVISION		GHJ				5/03																		

SCALE NOTED

TOLERANCES UNLESS OTHERWISE SPECIFIED	
FRACTIONS	±.01
XX DECIMALS	±.005
ANGLES	±0°15'
BREAK SHARP EDGES	06 MAX
FINISH	OTHERWISE SPECIFIED

ON COORDINATOR DATE

DES P. L. GORANSON/02
 DRW M. J. COLE 12/02

Oak Ridge National Laboratory
 managed for the DEPARTMENT OF ENERGY under
 U.S. GOVERNMENT CONTRACT NO. DE-AC05-80OR21400
 by BATTTELLE, LLC, Oak Ridge, Tennessee

NATIONAL COMPACT STELLERATOR EXPERIMENT

VACUUM VESSEL ASSEMBLY

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
8-	XX	XX	X	1	2	X	U
RELEASE LEVEL	WIP						REV
	SE120-001						A